

56747  
Work Order ID 56747-2

March 8, 2010 9:03:03 AM

Page 1

Item ID: D2571

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Fwd Out 205

Start Date: 10/03/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 23/03/2010 Req'd Qty: 8.00

Customer:

Reference: 10.03.08

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2571

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 56747 Double check by: [Signature] ☐ 1-Machine Step No 1  
per Folio FA051 and inspect per attached Dimension Sheets ☐ 2-Machine Step No 2  
per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3  
per Folio FA051 and inspect

MVF 10/03/10

Pto →

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

DJP 10/03/11 MVF 10/03/10

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MVF 10/03/10  
DJP 10/03/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: \_\_\_\_\_ Fault Category: Machined parts NCR: Yes No DQA: \_\_\_\_\_ Date: 10/03/15  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/03/30

NCR: <u>56747-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/03/13</u>	<u>#100</u>	<u>1 part fitted in 4 operation</u> <u>R.C. Pours / Tool dug into</u> <u>the parts because of vibration</u>	<u>[Signature]</u> <u>65/11/12</u>	<u>Scrap &amp; replace qty x1</u> <u>M 46412</u> <u>Additional clamps placed</u> <u>on the radius for extra support.</u>	<u>MMZ</u> <u>12/03/13</u>	<u>[Signature]</u> <u>10/03/24</u>	<u>[Signature]</u> <u>65/11/12</u>	<u>[Signature]</u> <u>11/03/15</u>

NOTE: Date & initial all entries



1. **THE COMPANY**  
 2. **THE PRODUCT**  
 3. **THE MARKET**  
 4. **THE COMPETITION**  
 5. **THE DISTRIBUTION**  
 6. **THE FINANCIAL**  
 7. **THE MANAGEMENT**  
 8. **THE LEGAL**  
 9. **THE ENVIRONMENT**  
 10. **THE FUTURE**

Page 2

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1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. Finally, the fifth step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and goals to determine the effectiveness of the project and identify areas for improvement.

1. The first step in the process is to identify the problem. This involves gathering information about the situation and understanding the needs of the stakeholders involved.

1. **Author(s):** [Redacted]  
 2. **Title:** [Redacted]  
 3. **Journal:** [Redacted]  
 4. **Volume:** [Redacted]  
 5. **Issue:** [Redacted]  
 6. **Pages:** [Redacted]  
 7. **Year:** [Redacted]  
 8. **DOI:** [Redacted]  
 9. **URL:** [Redacted]  
 10. **Abstract:** [Redacted]

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

**Reference:**

\_\_\_\_\_

[illegible]

**Insp.  
Stamp**

S.F 19/03/16

7

1

M 10/03/16

X7

~~Ø~~

111317 0

$\Rightarrow$   $\log_{10} 1000 = 3$

X7 0

START TIME: 2:20 pm □ OVEN TEMPERATURE:

2:50 ☐ FINISH TIME: 320°

## Powder Coating

# Work Order ID 56747

March 8, 2010 9:03:03 AM



Page 3

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 10/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 23/03/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

*Bk 10-3-16*

*(7)*

*9*



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: *433*

0.00



Packaging

Memo

0.00

Packaging

*10-143/22 (7)*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/03/24*

*mf*

*10-3-22*

# Picklist Print

Page 1

March 8, 2010 9:03:02 AM

Work Order ID: 56747



Parent Item: D2571



Parent Item Name: Saddle, Fwd Out 205

Start Date: 10/03/2010

Required Date: 23/03/2010

Comments: IPP: ☐ 02.10.02 ☐ Re-format; Change to Dwg Rev. D & incorporated  
D2572 ☐ KJ ☐

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	74.0000	8.0000			



Saddle Billet



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

74

41960

1

46412

73

MNE 10/03/07

8 71

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 56747
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		440	440	440	440		
B	1.745	1.755		1.746	1.747	1.747	1.747		
C	3.495	3.505		3.496	3.495	3.496	3.494		
D	1.745	1.755		1.746	1.747	1.747	1.747		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		.500	.510	.499	.500		
G	0.257	0.262		.258	0.259	0.259	0.259		
H	0.375	0.380		.377	0.377	0.377	0.377		
I	0.490	0.510		.490	0.498	.496	.498		
J	1.174	1.184		1.174	1.179	1.179	1.179		
K	0.558	0.578		.567	0.560	.560	.560		
L	1.174	1.184		1.175	1.179	1.179	1.179		
M	1.490	1.500		1.492	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.870	3.874	3.874	3.874		
P	0.115	0.135		.126	0.126	0.127	0.126		
Q	0.115	0.135		.127	0.135	.135	.135		
R	0.240	0.260		.247	0.248	0.250	0.249		
S	0.115	0.135		.128	0.130	.127	.126		
T	0.178	0.198		.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	0.235	.237	.235		
W	0.115	0.135		.125	0.120	.125	.125		
X	0.308	0.313		0.309	.310	.309	.310		
Y	0.760	0.765		0.761	.760	.761	.760		
Z	0.352	0.372		.367	.367	.365	.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		.626	.627	.627	.627		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.250	0.250	.250	.250		
AE	1.375	1.395		1.387	1.390	1.392	1.392		
AF	0.115	0.135		.135	0.139	.135	.135		
AG	0.240	0.280		.250	0.255	0.255	0.255		
AH	0.240	0.260		.250	0.244	.243	.245		
AI	2.000	2.020		2.002	2.005	2.005	2.005		
AJ	0.023	0.043		0.033	.035	.033	.033		
Accept/Reject									

Measured by:	JIP / MV
Date:	10/23/11 10/03/15

Audited by:	B.P.
Date:	10/03/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 56747
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	4	By	Date
A	0.438	0.443		.440	.440	.440			
B	1.745	1.755		1.747	1.747	1.747			
C	3.495	3.505		3.500	3.500	3.500			
D	1.745	1.755		1.747	1.747	1.747			
E	7.990	8.010		8.003	8.004	8.003			
F	0.490	0.510		.500	.500	.500			
G	0.257	0.262		.260	.260	.260			
H	0.375	0.380		.377	.377	.377			
I	0.490	0.510		.496	.497	.498			
J	1.174	1.184		1.179	1.179	1.180			
K	0.558	0.578		.560	.560	.560			
L	1.174	1.184		1.179	1.179	1.180			
M	1.490	1.500		1.498	1.498	1.498			
N	2.495	2.505		2.498	2.500	2.500			
O	3.869	3.879		3.876	3.875	3.874			
P	0.115	0.135		.127	.125	.125			
Q	0.115	0.135		.130	.133	.135			
R	0.240	0.260		.250	.248	.248			
S	0.115	0.135		.124	.124	.125			
T	0.178	0.198		.188	.188	.188			
U	2.940	2.980		2.960	2.960	2.957			
V	0.230	0.250		.237	.240	.234			
W	0.115	0.135		.127	.126	.125			
X	0.308	0.313		.310	.310	.310			
Y	0.760	0.765		.761	.761	.761			
Z	0.352	0.372		.365	.366	.365			
AA	0.470	0.530		.500	.500	.500			
AB	0.615	0.635		.622	.623	.628			
AC	0.053	0.073		.063	.063	.063			
AD	0.240	0.260		.250	.250	.250			
AE	1.375	1.395		1.390	1.393	1.394			
AF	0.115	0.135		.135	.135	.135			
AG	0.240	0.280		.275	.273	.248			
AH	0.240	0.260		.251	.253	.246			
AI	2.000	2.020		2.006	2.007	2.006			
AJ	0.023	0.043		.033	.033	.033			
Accept/Reject									

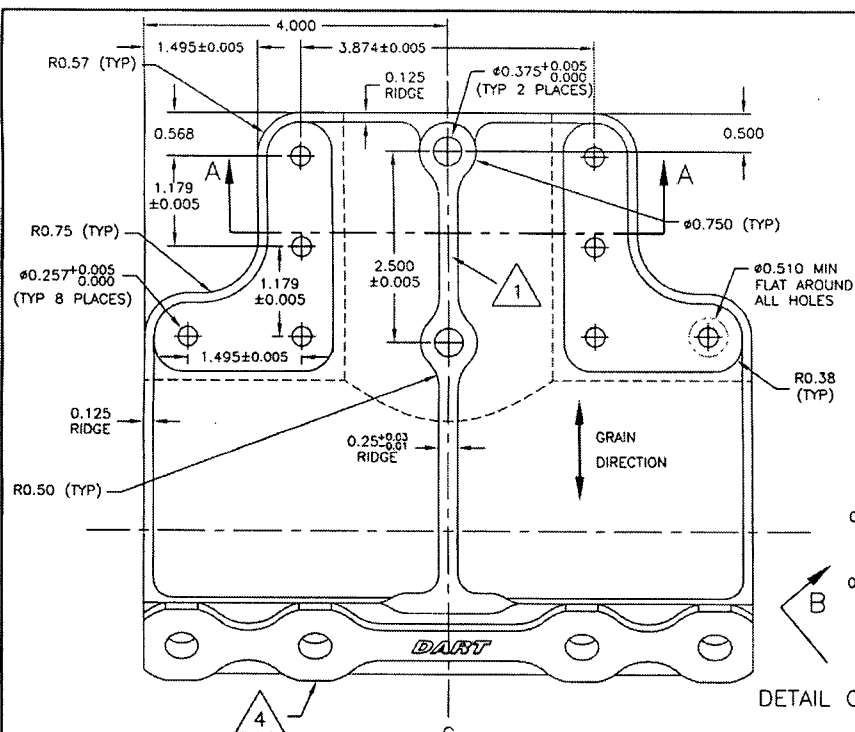
Measured by: MW
Date: 10/23/15

Audited by: LB
Date: 10/23/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	








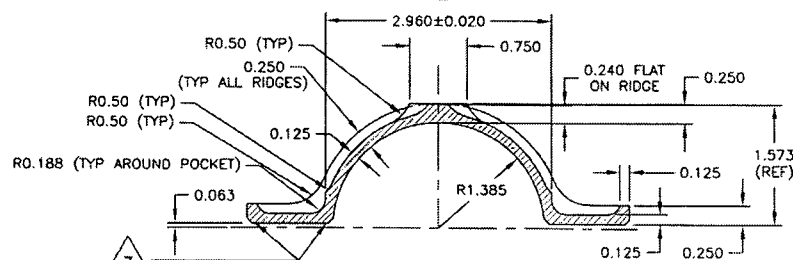
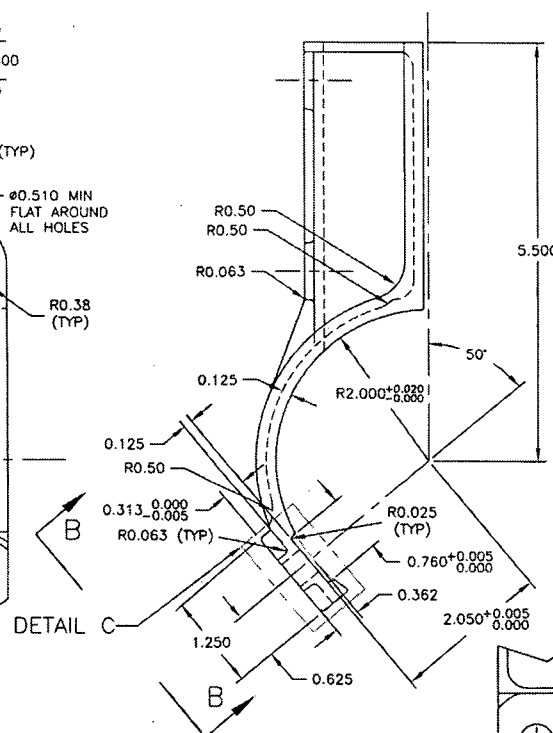
05.12.06



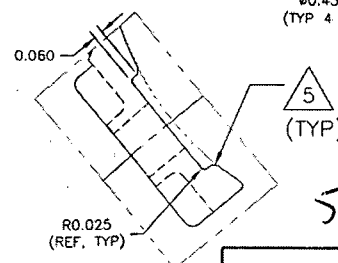
## NOTES

MATERIAL: 7075-T7351 (00-A-250/12) (REF DART SPEC. 06102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

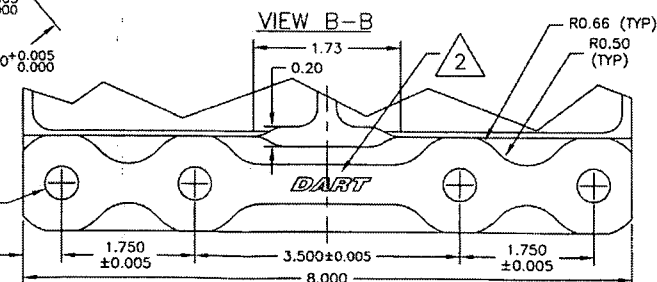
- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125       |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063" x 45° ALL AROUND                                  |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)                              |






SECTION A-A



DETAIL C  
SCALE 4:3



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2571
DATE 05.07.13		TITLE OUTER FWD SADDLE